

Work Order ID 130512

Friday, March 13, 2015 12:55:14 PM

130512

Page 1

Item ID: D3886-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug Assembly
 Start Date: 3/13/2015 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 3/13/2015 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 15-03-13 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3886	B								

100 0.00
100
 Waterjet Memo 0.00 10 0 Jm15-3-20
 FLOW CNC Waterjet
 304.100" 1-Cut as per Dwg D3886-3
 Dwg Rev: B
 Prog Rev: B
 2-Deburr if necessary

110 0.00
110
 QC Memo 0.00 10 0 Jm15-3-20
 Quality Control

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Lug Assembly

Start Date: 3/13/2015 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 3/13/2015 **Req'd Qty:** 6.00

6

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC8- Inspect parts - second check

0.00

120

0.00

OC

Memo

Quality Control

DAS
38
9-89

MAD 20 2015

130

0.00

130

0.00

Brake NC

Memo

Brake NC

form as per dwg D3886

**DAS
30
9-89**

30
9-89

DAS
38
9-68

MAR 31 2015

140

QC5- Inspect part completeness to step on W/O

0.00

140

0.00

QC

Memo

Quality Control

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Item ID: D3886-041 Accept *N900040100* Setup—Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lug Assembly
 Start Date: 3/13/2015 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 3/13/2015 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M 131545</i> Memo	0.00 <i>START: 10:00</i> <i>0.00</i> <i>QWEN.T: 1400°</i> <i>FINISH: 10:30</i>				<i>10</i>	<i>10-56</i>	<i>22 34 38</i>	
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>(10)</i>	<i>FF</i>	<i>MAY 06 2015</i> <i>38</i> <i>9-89</i> <i>MAY 06 2015</i>	
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <i>st 529</i> Memo	0.00 0.00				<i>10</i>	<i>DAS</i> <i>27</i> <i>9-89</i>	<i>MAY 07 2015</i>	

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MLS MAY 07 2015

Picklist Print

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Work Order ID: 130512

130512

Parent Item: D3886-041

D3886-041

Parent Item Name: Lug Assembly

Start Date: 3/13/2015

Required Date: 3/13/2015

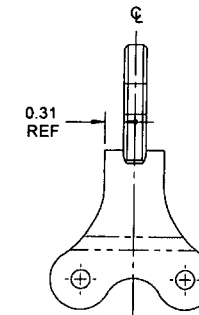
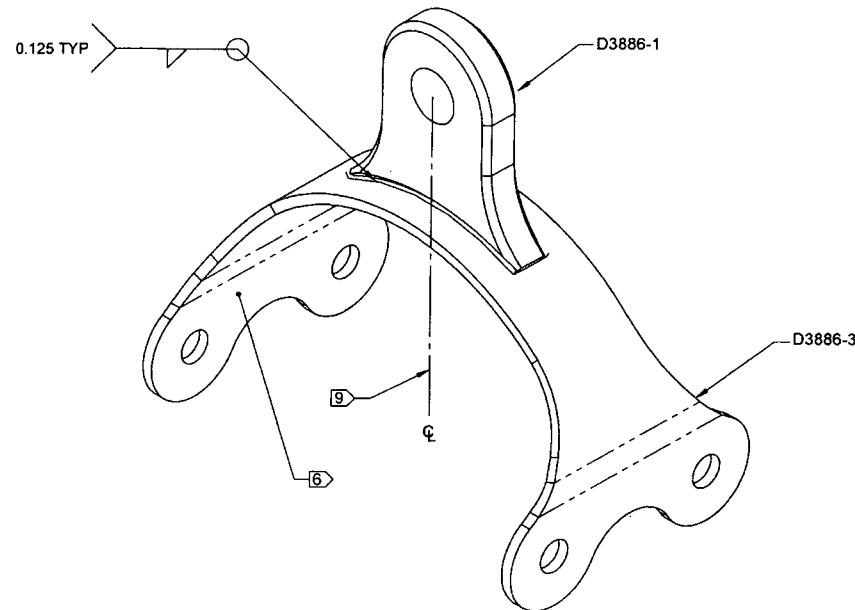
Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA *M304S12GA* 304/316 0.100" Sheet		Purchased	No			100	sf	87.2313	0.1472	<u>1</u>			
									**				<u>Jan 15-3-20</u>
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT019		87.2313							
				m131322		87.2313				<u>131322</u>			
D3886-1 *D3886-1* Lug		Manufactured	No			150	Each	12.0000	1	6			
									**				<u>EL 15-4-14</u>
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA002		12							
				124402		12				<u>10</u>			

ITEM	QTY	P/N	DESCRIPTION
1	X	D3886-041	LUG ASSEMBLY
2	1	D3886-1	LUG
3	1	D3886-3	BRACKET



130512
1503-13

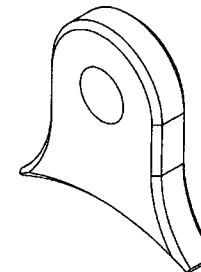
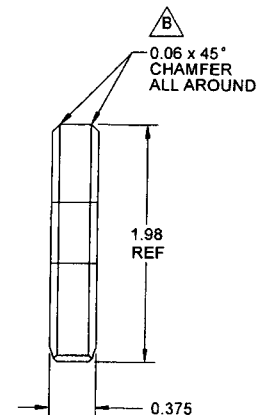
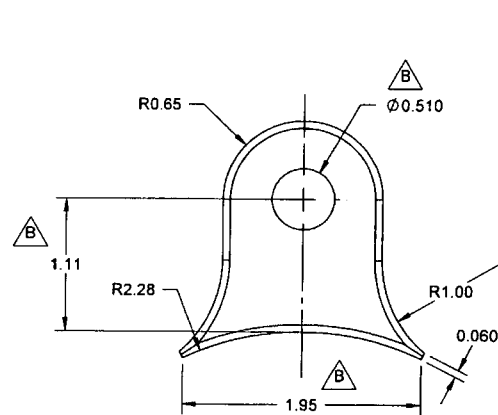
D3886-041 LUG ASSEMBLY

RELEASED
06/15/13

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3886-041" AND BATCH NUMBER USING FINE POINT PERMANENT INK MARKER ON UNDERSIDE OF PART
- 7) WEIGHT: 0.53 lbs
- 8) WELD PER DART QSI 004
- 9) BOTH PARTS CENTER SHOULD BE IN LINE WITH THE C

B	RE-DESIGN D3886-1 (ZN B4-2); RE-DESIGN D3886-3 (ZN A4-3); REVISED D3886-3F (ZN B4-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3886	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	LUG ASSEMBLY	NTS
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D3886-1 LUG (B)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR (REF. DART SPEC. M304B0.750X2.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

RELEASED
09/07/00

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CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3886	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG ASSEMBLY	NTS
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8

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3

2

1

D

C

B

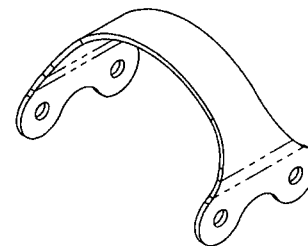
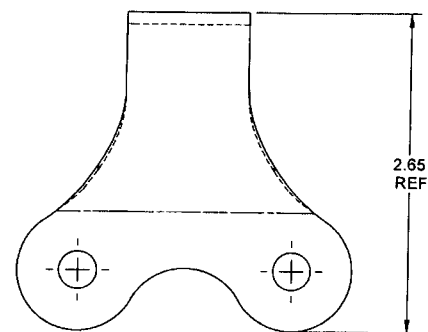
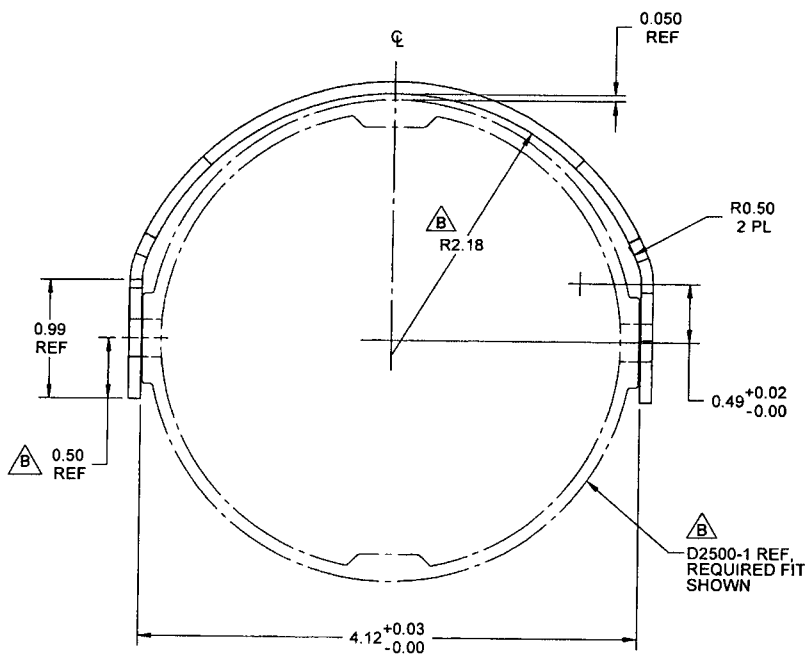
A

D

C

B

A



D3886-3 BRACKET B
(MAKE FROM D3886-3F)

RELEASED
9/6/15

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MFG. APPR.	<i>[Signature]</i>		SHEET 3 OF 4
APPROVED		TITLE LUG ASSEMBLY	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DATE	09.06.30		

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7

6

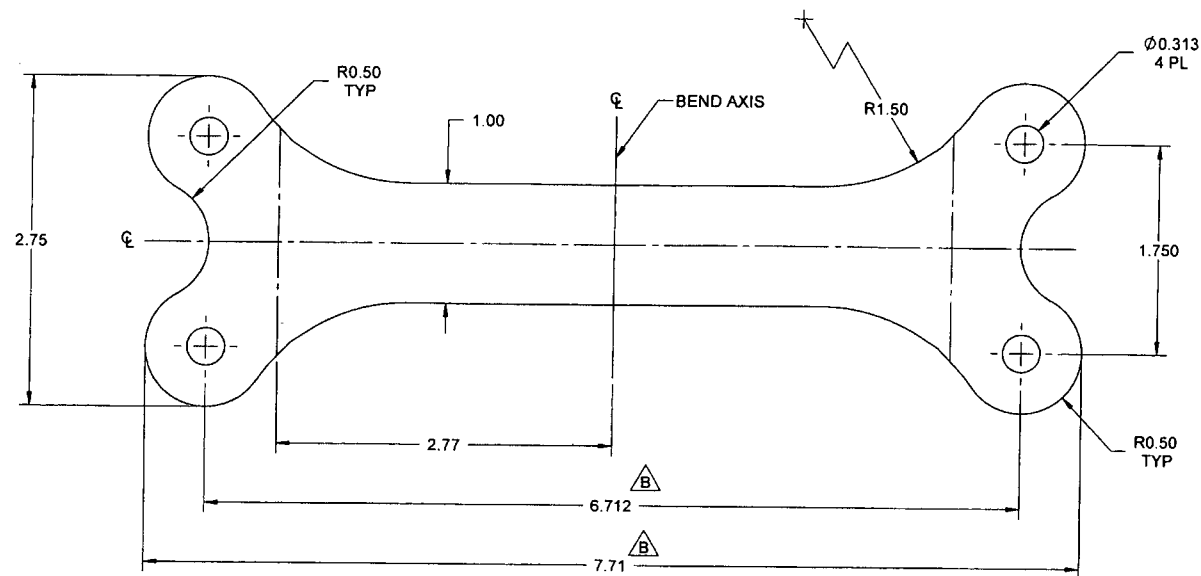
5

4

3

2

1



D3886-3F FLAT PATTERN $\triangle B$

RELEASED
8/6/15

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 12 GAUGE (0.100) THICK, (REF. DART SPEC. M304S12GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.30 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3886	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG ASSEMBLY	NTS
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